

Date: Wednesday, 29/04/2009 10:12:07 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 350 SKIDTUBE ASSEMBLY LH |
| Job Number : 47577 | |
| Estimate Number : 10266 | |
| P.O. Number : | Part Number : D350636013 |
| This Issue : 29/04/2009 S.O. No. : | Drawing Number : D2750 REV F |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SKIDTUBES | Drawing Revision : F |
| Previous Run : 47576 | Material : |
| Written By : | Due Date : 10/05/2009 Qty: 1 Um: Each |
| Checked & Approved By : JLD 09.04.29 | |
| Comment : | |
| Est Rev:H 02.09.25 Rearranged procedure steps KJ | |
| est rev I 06.03.30 Per rev. D dwg EC | |
| Est Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM | |
| Verified By:EC | |
| Est Rev:K 08-09-23 revF as per dwg DD verified by:ec | |
| Est Rev:L 09-02-06 apply antiseize on AN8C21A bolts as per | |
| PAR09-010 DD verified by:EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



for JLD 09/05/11



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 004

809/05/19

| | | |
|-----|------------|----------------|
| 2.0 | D26003BENT | Extrusion Bent |
|-----|------------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B47133 D

M 9-5-4

| | | |
|-----|-------|-----|
| 3.0 | D2744 | Cap |
|-----|-------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B C11892 D

M 9-5-4

| | | |
|-----|-------------|-----------------------|
| 4.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 6 (D2750-3 details).Drill using drill Jig DT8150 & DT8864 .

M 9-5-4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for the blade fitting bolt holes using DT8983. Open to 0.500".

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting.

6-Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail S to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M110972 BE 9-5-4*

12-Grind welds flush as per Dwg D2750 *BE 9-5-4*

13- scribe batch #.

u 9-5-4

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 09/05/04

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/04

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pr 09-05-04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION


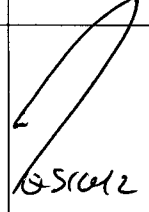
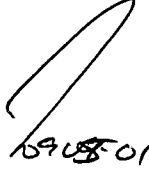


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D u 9-5-5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: D350-636-013 PAR #: N/A Fault Category: Prod/Skid tube NCR: (Yes) No DQA: AD Date: 09/05/05
 Resolution: _____ Disposition: _____ QA: N/C Closed: AD Date: 09/05/05

| NCR: <u>47577</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------------|--|--|---|--------------------------|-----------------------------|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>09/05/01</u> | <u>4.0</u> | Tube is scrap. 0.3125 hole was opened up to 0.5" diameter. Hole is too large to re-work and is a flast hole. Employee grabbed wrong drill. P.C: Human error in training. |  | Ensure to verify drill size being used at all times. Scrap & replace with this w/o Qty 1 B 47133 D | <u>#</u> <u>9-5-4</u> | <u>S</u> <u>09/05/04</u> |  |  |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

B47707

①

M

9-5-5

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B47118

④

M 9-5-6

11.0

D34905

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B416400

⑤

M 9-5-6

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

B45555

⑧

M 9-5-6

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

2- Open holes section AV-AV 0.3125" (4 per side)

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

M11021

exp. date: 12-1-1

M

9-5-5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 10)

A/R Aluminum Rod batch:

M110972 BE 09/05/06

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

> fm'09-05-06

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 09/05/07 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/07 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

09-05-11 (X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

m111472
FD 09/05/11

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

09-05-14 (X)

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: *M110768*

09-05-14 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09/05/11 | 17.0 | Start time: 11:35 Temp: 320° Finish time: 12:05 | FL | 09/05/11 | ① | | G 09/05/11 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Install inserts as per dwg D2750

JP

09-05-14

(K1)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: 1346695

JP

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 1347210

JP

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: 1347537

JP

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: 47211

JP

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket
Batch: 1347721

JP

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket
Batch: 1347440

JP

09-05-14

(K1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1347201

Handwritten initials

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1347526

Handwritten initials

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 1347530

Handwritten initials

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 1347437

Handwritten initials

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: 1341853

Handwritten initials

32.0

NAS1611010

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

NAS1611-010 batch: _____

(or MS28775-010) batch: _____

Handwritten asterisk

Handwritten initials

09-05-14 (X) (PJO) =>

33.0

D34921

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

batch: 1347472

Handwritten initials

09-05-14

(X)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|------|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 09-05-14 | 32.0 | Replace "O" Rings NAS 1611-010 FOR 02594-3 1329908 | gl | 09-05-14 | (X8) | | S 09/05/14 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

NAS1611005

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

11106009

24

35.0

D34925

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

batch: 1347659

24

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: 1111707

21

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 11110372

24

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 11110865

24

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: 11110105

24

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: 1111668

21

09-05-14

21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47577

Part Number: D350636013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
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|------|------------|--------|
| 41.0 | AN960C816L | WASHER |
|------|------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: 11110372

44

| | | |
|------|----------|-----|
| 42.0 | MS210436 | NUT |
|------|----------|-----|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: 11110584

44

| | | |
|------|-----------|-----|
| 43.0 | MS21083C8 | NUT |
|------|-----------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: 11110584

44

| | | |
|------|------------|--------|
| 44.0 | NAS1515H3L | WASHER |
|------|------------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: 11110806

40

| | | |
|------|-----------------|----------------------------|
| 45.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

X 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

✓ BATCH: 11111081

EXP DATE: 10/20

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 11101223

5-Coat all exposed fasteners with "LPS Procyon" batch: 11104251 94 09-05-14 KL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/15 (10)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: 1345320

8

9/5/19

SL

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M111424

5

9/5/19

sel

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M111637

8

9/5/19

SP

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M110342

5

*****apply antiseize prior to packaging*****

Batch: M110658

9/5/19

SL

52.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: M108964

5

9/5/19

SL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 10:12:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 47577

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

D34931

Washer



(K)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: *but902*

9/5/19

34

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*****ensure antiseize is on AN8C21A bolts*****

8 09/05/19 (K)

55.0

PACKAGING 1

PACKAGING RESOURCE #1



(K)
SD

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev C 9/5/20

56.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/21 (K)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-20

B 47577

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|---|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

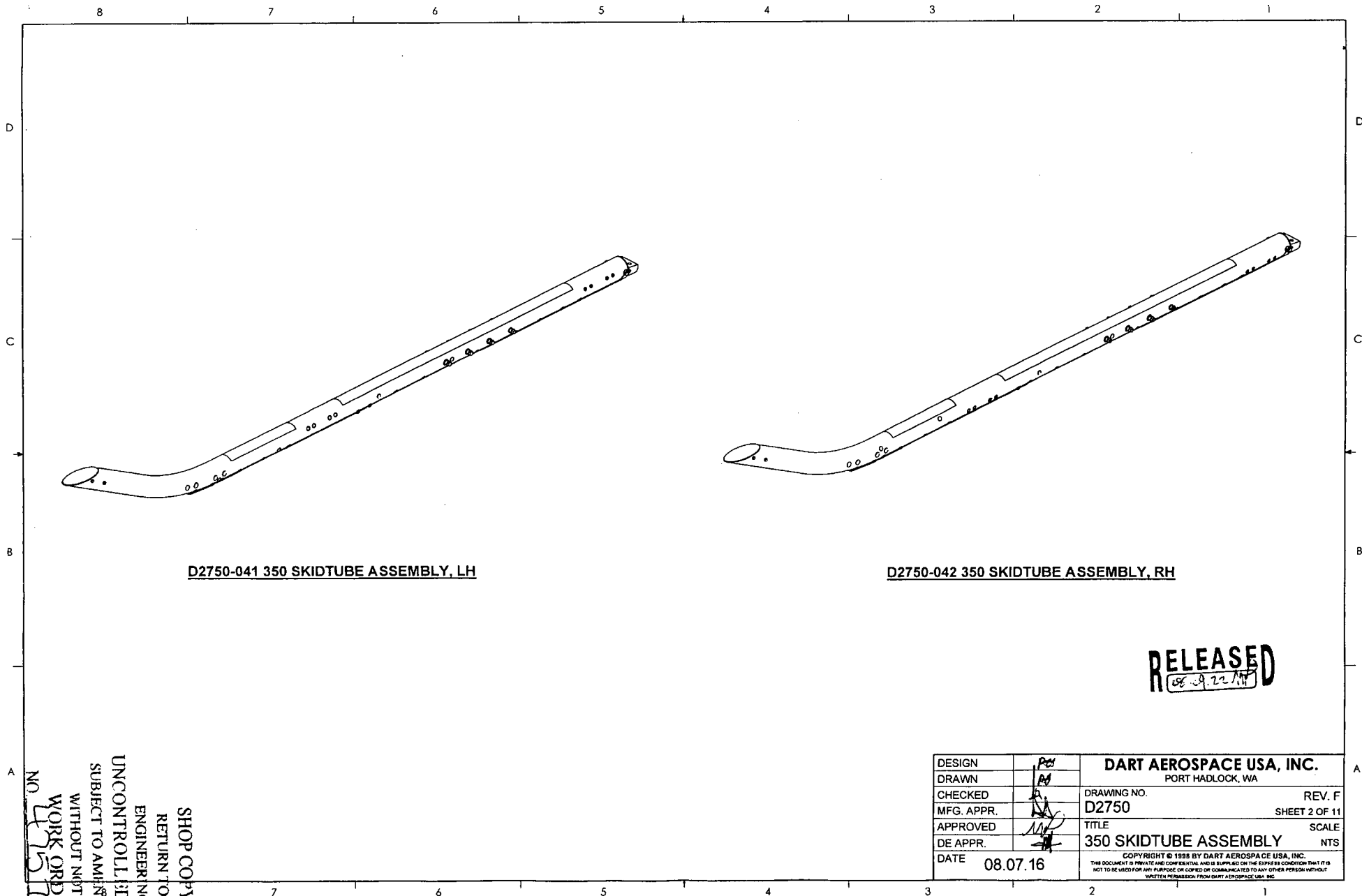
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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|------------|--|--|---------------|
| F | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
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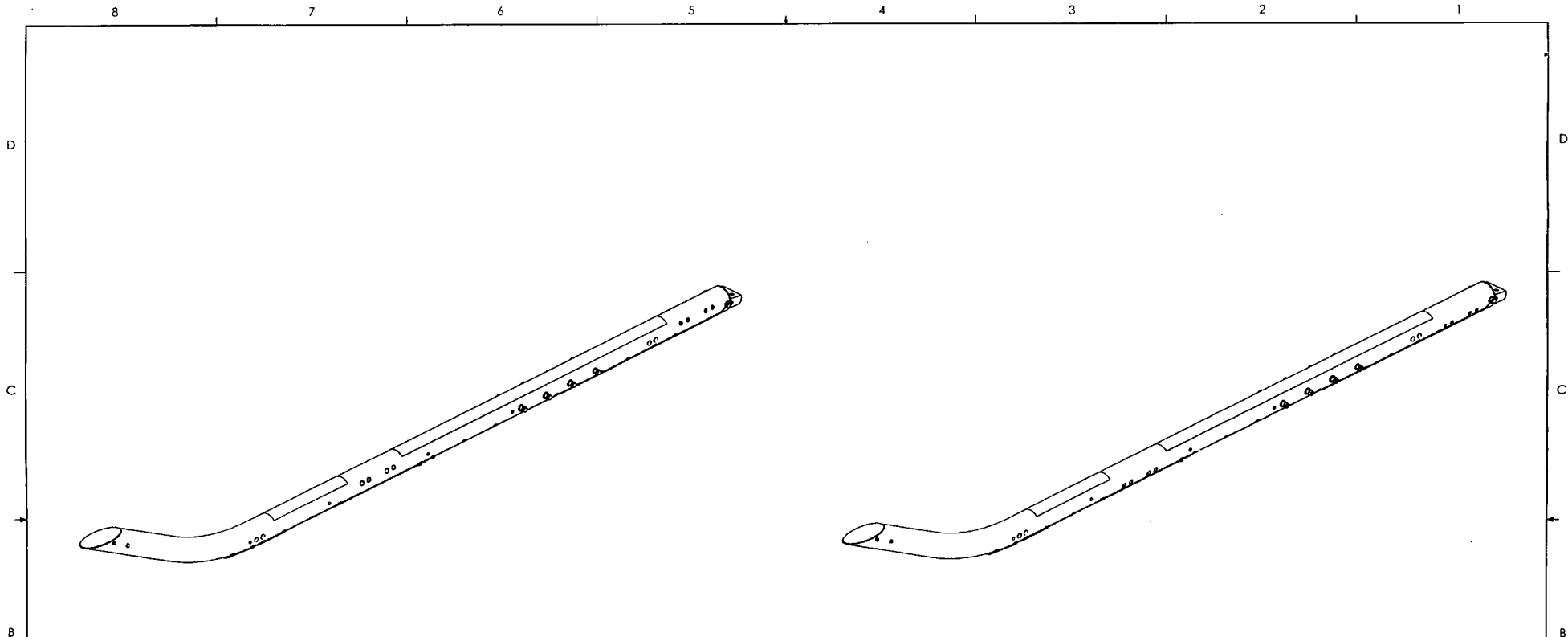
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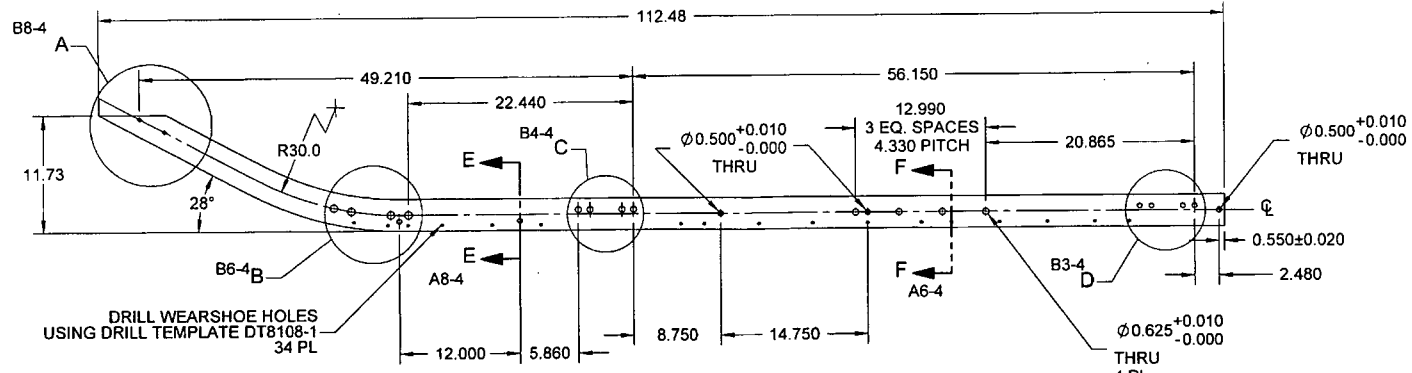
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

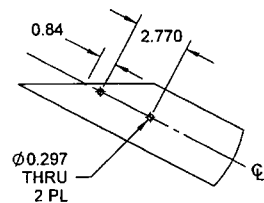
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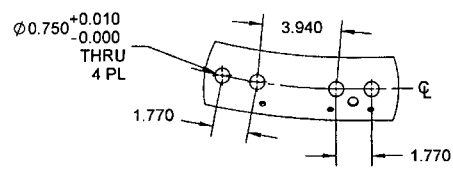
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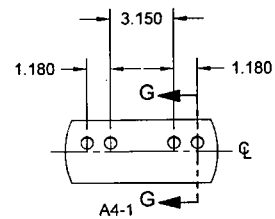
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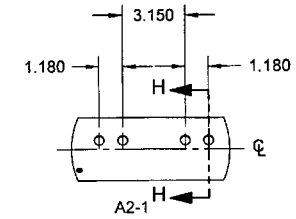
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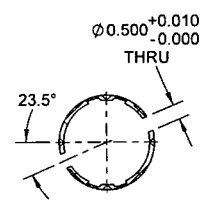
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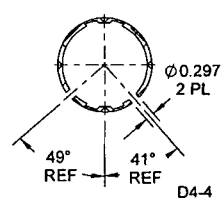
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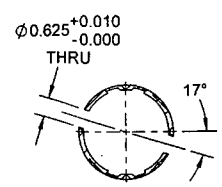
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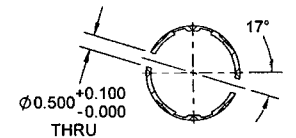
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SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
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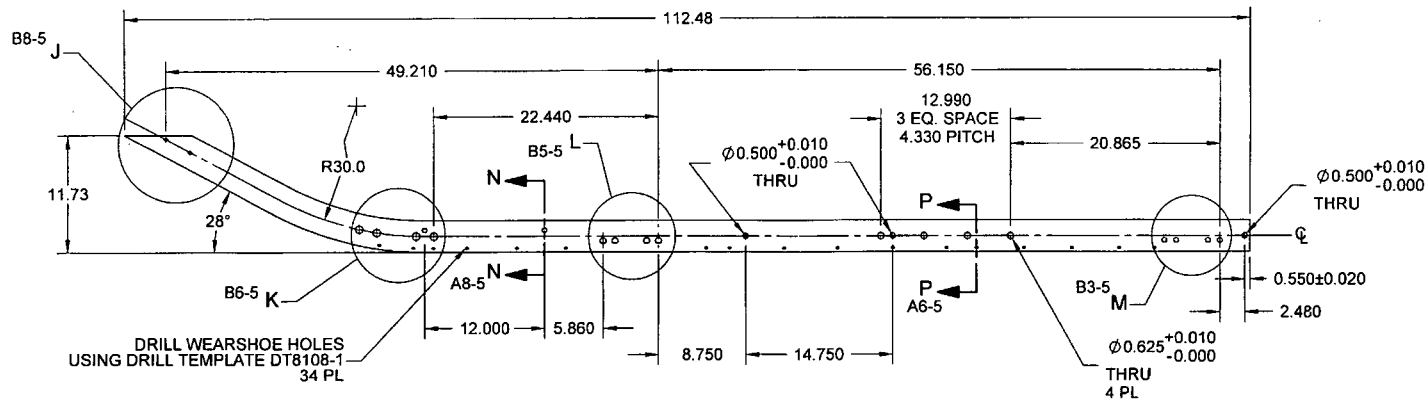


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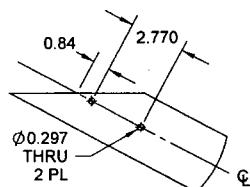
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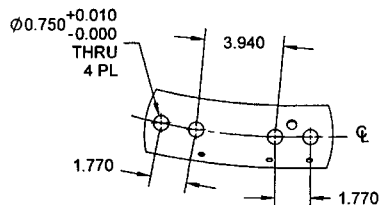
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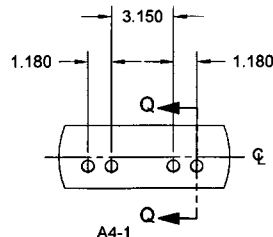
D2750-2 RH SKIDTUBE



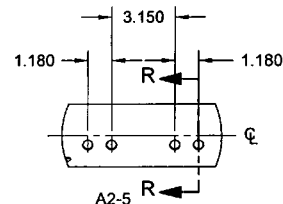
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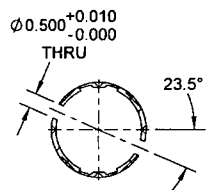
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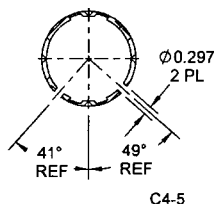
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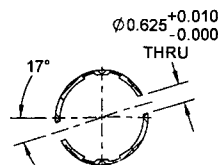
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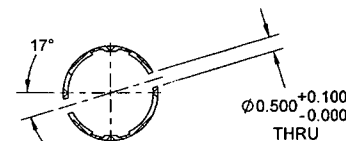
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SECTION Q-Q
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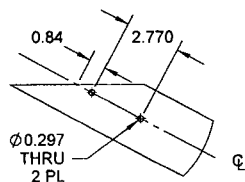
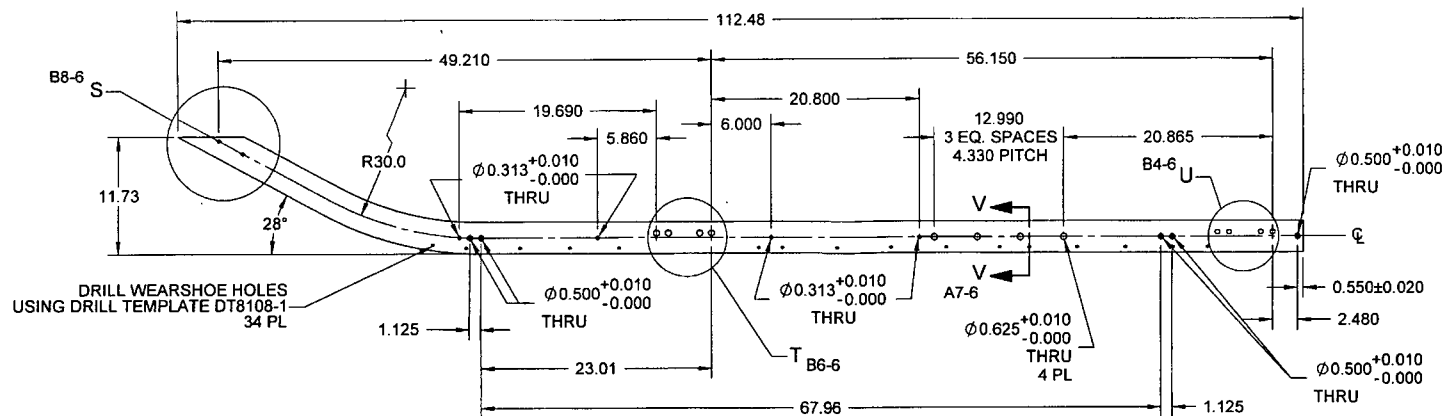
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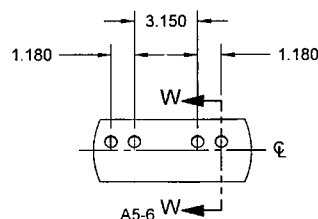
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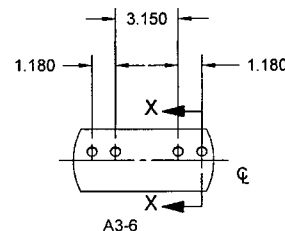
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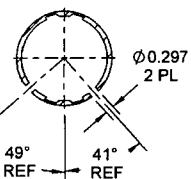
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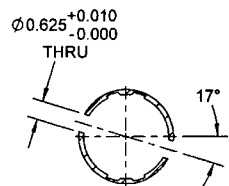
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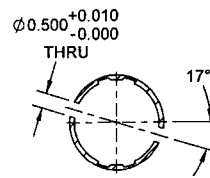
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C4-6
SECTION V-V
SCALE 3X, 4 PL



B6-6
SECTION W-W
SCALE 3X, 4 PL

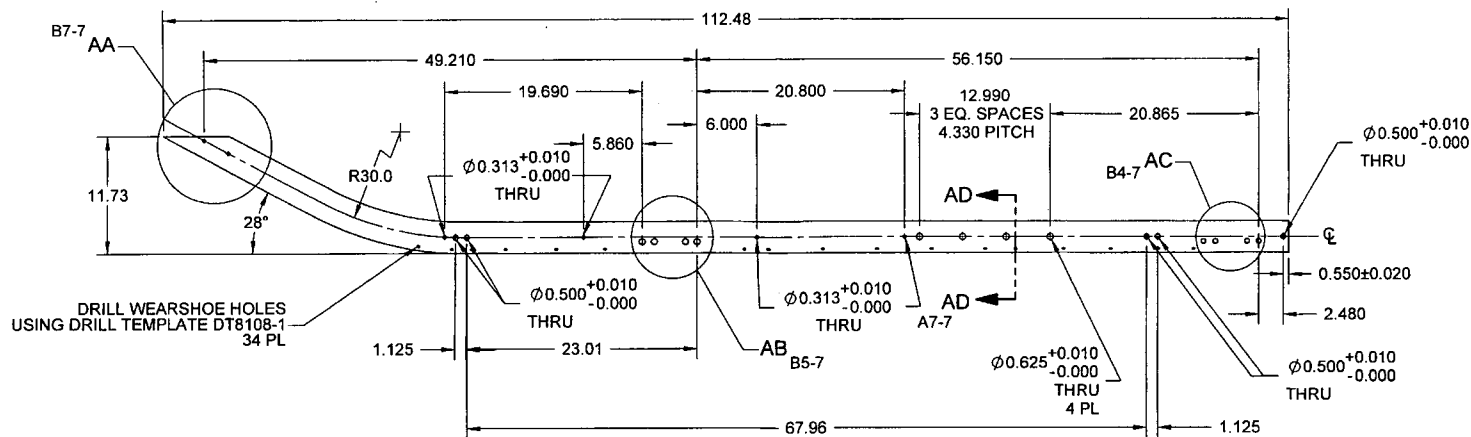


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SECTION X-X
SCALE 3X, 4 PL

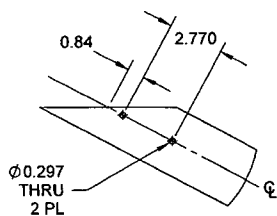
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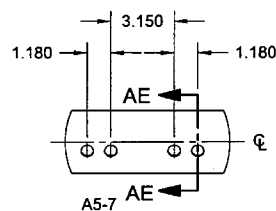
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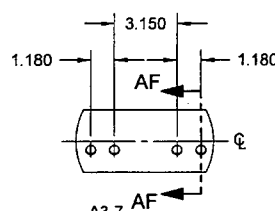
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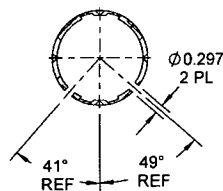
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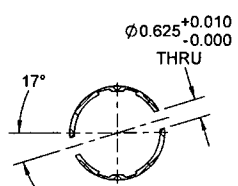
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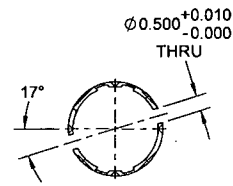
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

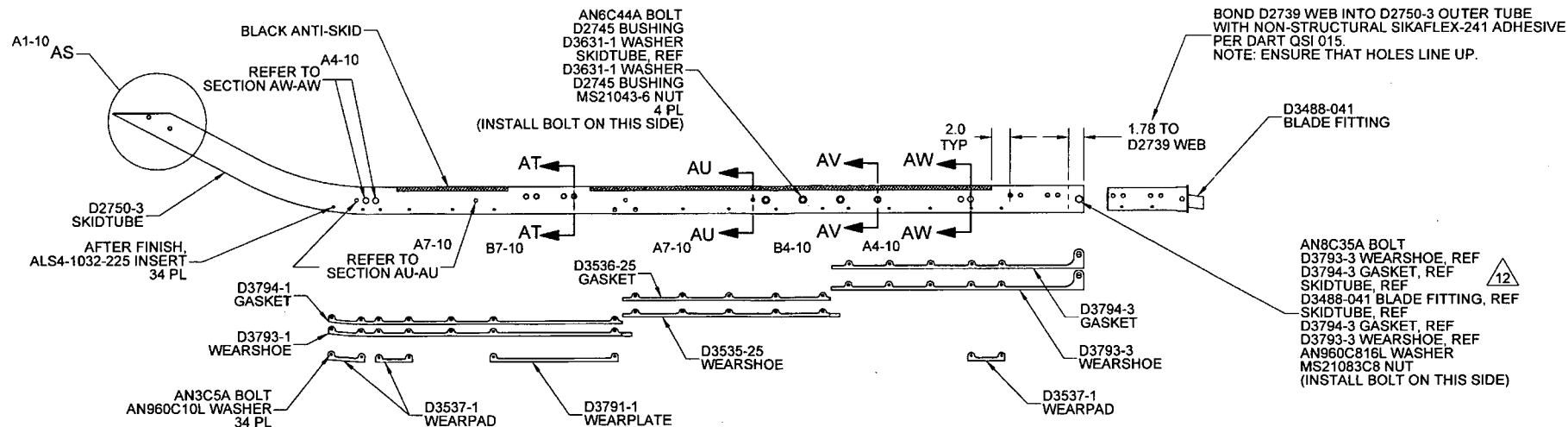


SECTION AF-AF
SCALE 3X, 4 PL

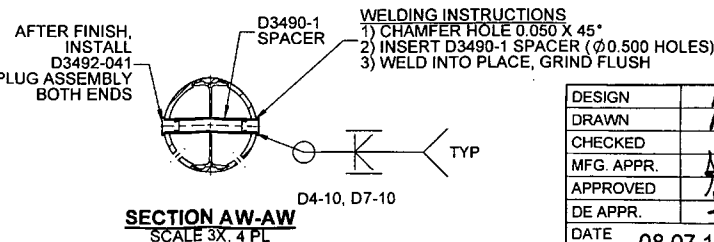
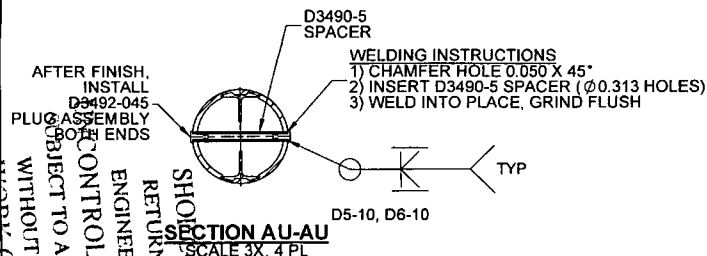
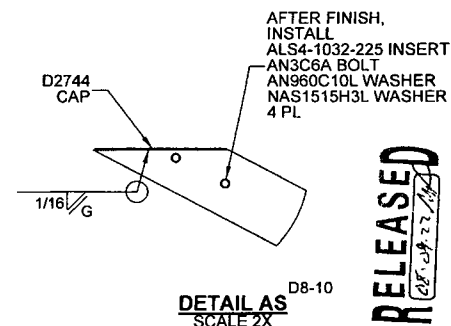
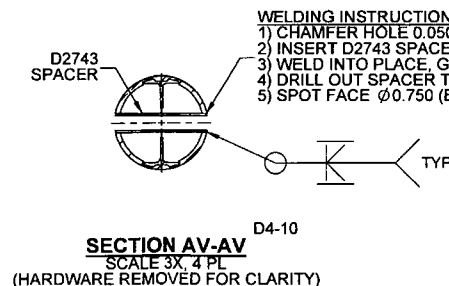
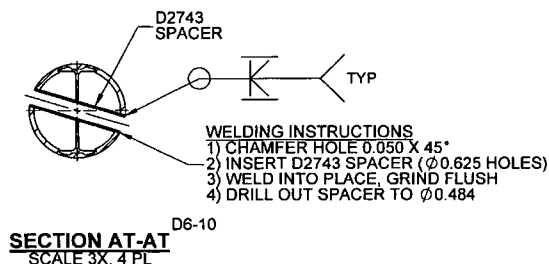
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| MFG. APPR. | | D2750 | SHEET 7 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



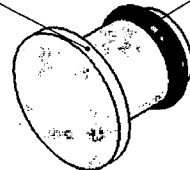
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| DE APPR. | | | NTS |
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D3492-045
PLUG ASSEMBLY
BOTH ENDS
AFTER FINISH,
INSTALL

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08.07.16

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | | | | | | | D3492-041 | PLUG ASSEMBLY |
| | X | | | | | | D3492-043 | PLUG ASSEMBLY |
| | | X | | | | | D3492-045 | PLUG ASSEMBLY |
| | | | X | | | | D3492-047 | PLUG ASSEMBLY |
| | | | | X | | | D3492-049 | PLUG ASSEMBLY |
| | | | | | X | | D3492-051 | PLUG ASSEMBLY |
| | | | | | | X | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | 1 | | | | | NAS1611-005 | O-RING |
| | | | 1 | | | | NAS1611-007 | O-RING |
| 1 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | 1 | NAS1611-012 | O-RING |
| | 1 | | | | | | NAS1611-013 | O-RING |
| | | | | | 1 | | NAS1611-015 | O-RING |
| | | | | 1 | | | NAS1611-016 | O-RING |

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~
OK ASS 06.11.12

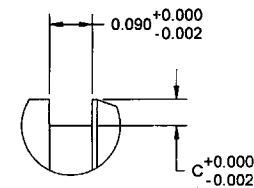
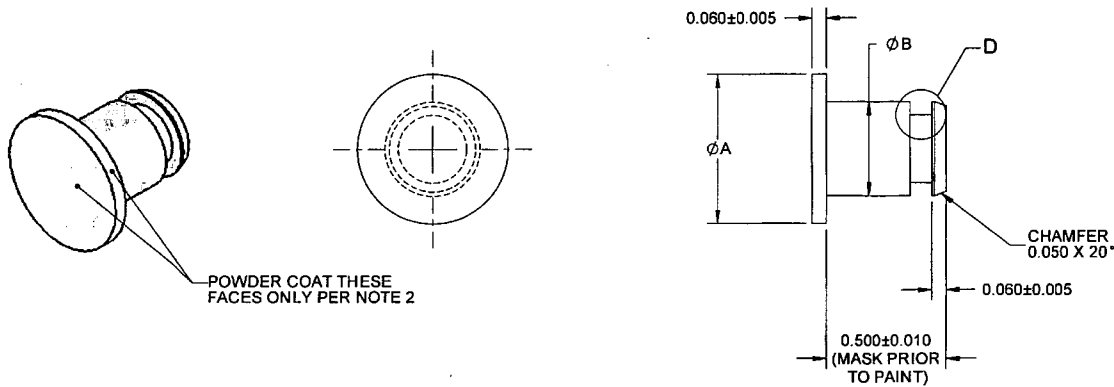
DEO ATTACHED

RELEASED
07.10.05

| | | | |
|------------|---|--|----------|
| C | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047; UPDATE DIM A FOR -045 | PH | 06.05.11 |
| A | NEW ISSUE | PH | 08.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3492 TITLE PLUG SCALE 2:1 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | REV. C | |
| DATE | 07.10.05 | SHEET 1 OF 2 | |

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8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-1 | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |
| D3492-9 | 0.938 | 0.750 | 0.045 | M6061T6R1.000 |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 |
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

UNDER REVIEW
01.07.11
DESIGN BY D. J. [signature]
REV. 02 (HAWKESBURY)
ASS 08.11.12
OKay

DEO ATTACHED

RELEASED
07.11.16

| | | | | |
|---|-----------|--|-----------------------------|--------|
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| DRAWN | <i>PL</i> | | | |
| CHECKED | <i>PL</i> | | DRAWING NO. D3492 | REV. C |
| MFG. APPR. | <i>PL</i> | | SHEET 2 OF 2 | |
| APPROVED | <i>PL</i> | | TITLE | SCALE |
| DE APPR. | <i>PL</i> | | PLUG | 4:1 |
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7 6 5 4 3 2 1

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|----------------------|------------------|------------------|---|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3492 | TITLE PLUG | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3492-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED | MFG. APPR. | APPROVED | | DE APPR. | | |
| DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08/11/05 | | DATE 08/11/05 | | |

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 |

WAS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

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08/11/10

NO. 197

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 47399
Part number: D350 636 012
Description: 3.50 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pct. Dent Date of Test Coupon 09-04-27
Welder Barday Elliott Date of Test Coupon 09-04-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld